

Date: Wednesday, 11/28/2007 2:19:54 PM
User: Kim Johnston

Process Sheet

50

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 SKIDTUBE ASSEMBLY LH
Job Number : 36006	
Estimate Number : 10262	
P.O. Number : N/A	Part Number : D350636011
This Issue : 11/28/2007 S.O. No. : N/A	Drawing Number : D2750 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : E
Previous Run : 36005	Material : N/A
Written By : <u>John. 11 28</u>	Due Date : 12/12/2007 Qty: 1 Um: Each
Checked & Approved By : <u>John. 11 28</u>	
Comment : Est Rev: 02-09-25 Rearranged procedure steps KJ Est Rev: J 06-03-23 As per Rev D JLM Est Rev: K 06-07-13 As per dsi9343 EC Est Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



KS 0.11 29

Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 003

08/6/17

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-3-Bent	Extrusion (Bent)	B35527011

7-11-30

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch: B33996 BE 07-12-03

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2- Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8863.

7-11-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Seq. #:	Machine Or Operation:	Description :
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3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for Detail B using DT8330

5-Open up holes for Detail B to 0.375" and blade fitting location holes to 0.500" as per dwg D2750 .Open up detail E to 0.500". Open up ground handling holes to 0.500".

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297" *****Make sure that wearplate holes are on bottom of tube***** Open holes to detail A to 0.297"

7-Open up holes of Detail A to 0.250" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *m 106035/m 105138* *BF 7-12-03*

10-Grind welds flush as per Dwg D2750

12- Scribe batch# inside per dwg D2750

7-11-30

SL 7-12-03

A 7-11-30

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AD 07-12-04

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

A 12-6-04

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 7-12-04

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BF 7-12-04

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web
Batch: *35991*

SL 7-12-04

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Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B33824 BE 07/12/05

11.0

D34903

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B33825 BE 07/12/05

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: B34309 BE 07/12/05

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail D to 0.750" (total of 4 holes per side)
as per dwg D2750.

3-Chamfer holes of Detail V, Detail C, Detail D and hole size "W" per dwg D2750 (welding instructions on sheet 4)

4-Deburr and blow out all chips from inside of tube

6-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch: 105488

exp. date: 6-7-1

7- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 4)

A/R

Aluminum Rod

batch: m 106035 BE 07/12/05

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750

SL 7-12-04

SL 7-12-05

W/O:		WORK ORDER CHANGES						
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Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

10-Deburr holes

SL 7-12-5

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-12-06 (1)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SL 07/12/06 (80)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

BR 07-12-06

⑦

17.0

POWDER COATING

POWDER COATING .



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

M105914

(12)

m-l 07/12/06

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

FL 07/12/07 (1)

19.0

ALS41032225

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Insert

Batch: m/00489

FL

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install inserts as per Dwg D2750

FL 07/12/07 (1)

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B35688

FL 07/12/07 (1)

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Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D353513

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B35562

FL

23.0

D353525

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B35563

FL

24.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B34883

FL

25.0

D353613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: ~~B35564~~ B35565

FL

26.0

D353625

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B35566

FL

27.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B34828

FL

28.0

D35371

WEARPAD



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

WEARPAD

Batch: B35696

FL 01/12/07

①

W/O:		WORK ORDER CHANGES						
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Job Number: 36006

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D36311

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: B34276

FL

30.0

D3488041

BLADE FITTING ASSEMBLY, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B32232

FL

31.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B35217

FL

32.0

D3492043

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B33076

FL

33.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Bolt

Batch: B106431

FL

34.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: m105057

FL

35.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: m105906

FL 07/12/07

①

W/O:		WORK ORDER CHANGES						
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Job Number: 36006

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: m106065

FL

37.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: m102671

FL

38.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: m106431

FL

39.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: m106043

FL

40.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: m103693

FL

41.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: m104625

FL

42.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: m105116

FL 07/12/07 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 36006

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

43.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M105430

FL

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: M105005

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M105585

EXP DATE: 08-07

4-Coat all exposed fasteners with "LPS Procyon" batch: M104251

FL 07/12/10

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/12/10 (1)

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

47.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: B35435

FL 08/11/10 (1)

48.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M105160

FL 11/12/10 (1)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 36006

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

49.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M10643

50.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M105430

51.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M106431

52.0

D34931

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: 36034

53.0

D35321

spacer



Comment: Qty.: 2.0000 (s)/Unit Total : 2.0000 (s)

batch:

33085

54.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

55.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

Low F 8/1/17 SP (12) AS

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 09/01/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 36006

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

56.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

Dec 10, 118

Job Completion



2008/1/17

u

36006

W/O:		WORK ORDER CHANGES						
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DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. E SHEET 2 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

GENERAL NOTES:

RELEASED
07.08.02 [Signature]

1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4. WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ($\emptyset 0.297$) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
36006

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INSTALL ALS4-1032-225
INSERTS (4 PLACES)
AFTER FINISH

D2750-1 (LH) OR
D2750-2 (RH)

INSTALL ALS4-1032-225
WEARSHOE INSERTS (38 PLACES)
AFTER FINISH

**D2750-041 ASSEMBLY (SHOWN)
D2750-042 ASSEMBLY (OPPOSITE)**

BOND D2739 WEB INTO D2750-1 (OR D2750-2)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

BLACK ANTI-SKID

2.0
(TYP)

1.78 (REF)
(TO D2739 WEB)

D3488-041
(OR D3488-042)

NO INSERT

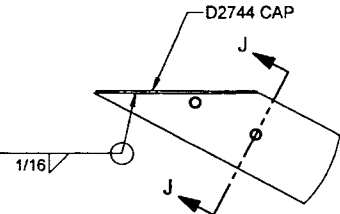
WELDED SPACER
NOT REQUIRED

D3535-35
D3536-35

AN3C7A BOLT (REF)

D3537-1

RELEASED
07.05.17



DETAIL H
SCALE 1:5

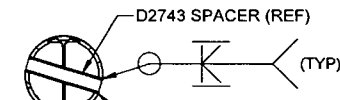
INSTALL:
AN3C6A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(4 PLACES)

SECTION J-J
SCALE 1:5

INSTALL AT AFTMOST
D3537-1 WEARPAD:
AN3C7A BOLTS (1)
AN960C10L WASHER (1)
(4 PLACES)

INSTALL:
AN3C5A BOLT (1)
AN960C10L WASHER (1)
(38 PLACES)

SECTION N-N
SCALE 1:5



SECTION M-M
SCALE 1:5

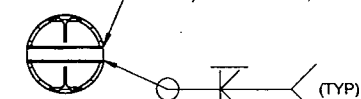
- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 x 45°
 - 2) INSERT D2743 SPACER
 - 3) WELD INTO PLACE
 - 4) GRIND WELD FLUSH
 - 5) DRILL OUT SPACER TO Ø0.484
 - 6) SPOT FACE Ø0.750 (SECTION P-P ONLY)

INSTALL:
AN6C44A BOLT (1)
D2745 BUSHING (2)
D3631-1 WASHER (2)
MS21043-6 NUT (1)
(4 PLACES)

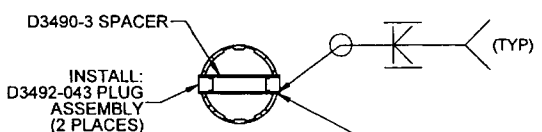
SECTION Q-Q
SCALE 1:5

INSTALL:
AN8C35A BOLT (1)
AN960C816L WASHER (2)
NAS1515H8L WASHER (2)
MS21083C8 NUT (1)

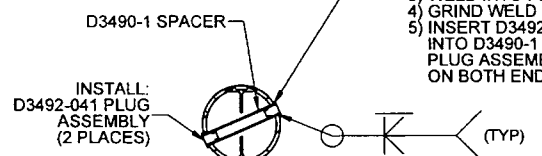
SECTION R-R
SCALE 1:5



SECTION P-P
SCALE 1:5



SECTION K-K
(FOR Ø0.750 HOLES ONLY)
SCALE 1:5



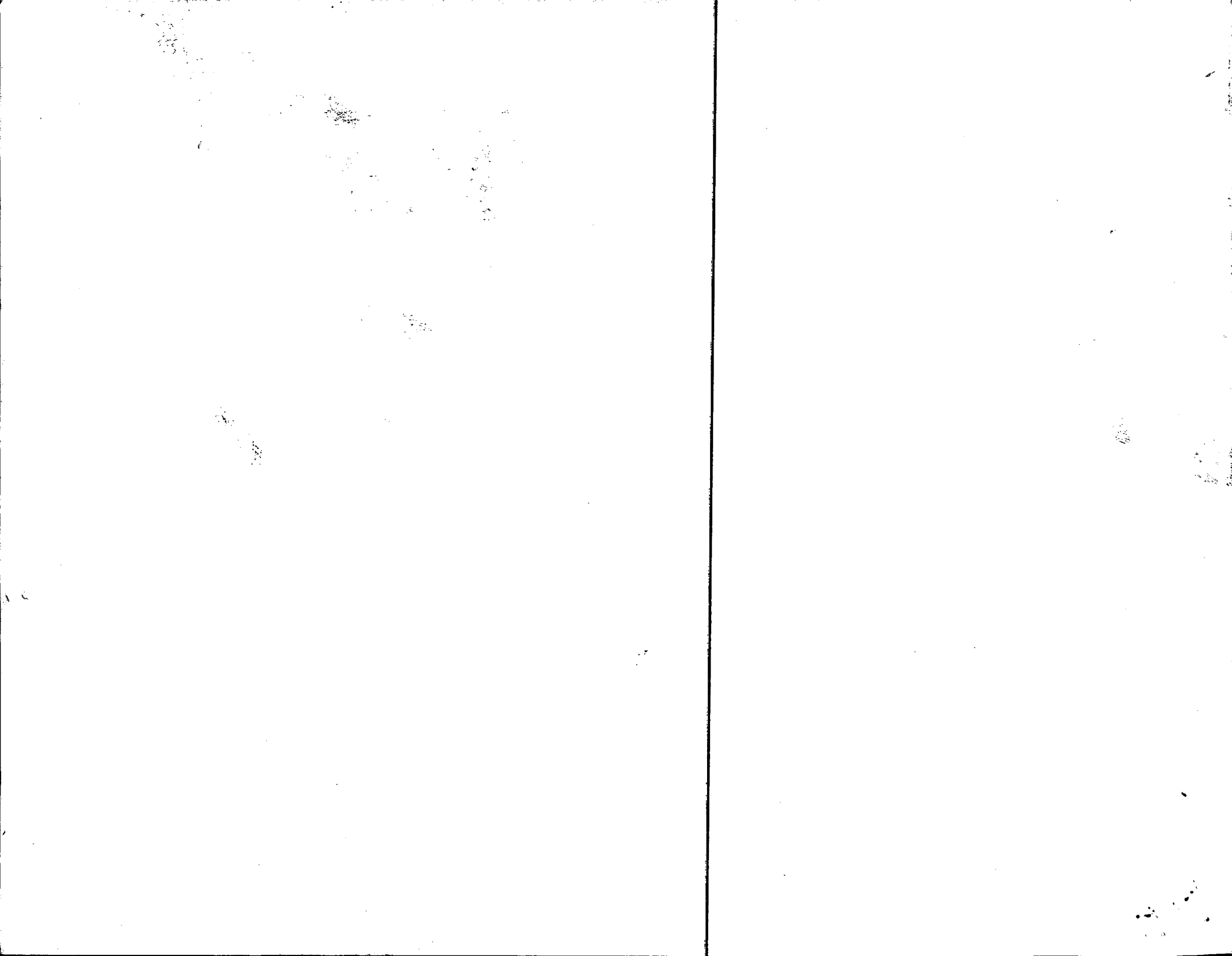
SECTION L-L
(FOR Ø0.500 HOLES ONLY)
SCALE 1:5

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 x 45°
 - 2) INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES
 - 3) WELD INTO PLACE
 - 4) GRIND WELD FLUSH
 - 5) INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS AFTER FINISH

NO. 36006
WORK ORDER
SUBJECT TO AMENDMENT
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SHOP COPY

DESIGN	DH	DRAWN BY	CB	DART AEROSPACE USA, INC.	
CHECKED	DH	APPROVED	[Signature]	PORT HADLOCK, WA	
DATE	07.05.17	DRAWING NO.	D2750	REV. E	SHEET 4 OF 5
TITLE			350 SKIDTUBE ASSEMBLY		
SCALE			1:10		

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NO. 132

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliot
Joint Welding Procedure tig
Part number and Job number B350 / B3550

TEST WELDS REQUIRED

BASE METAL Aluminum WELDING PROCESS tig
Penetration Complete ☒ Partial ☐ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input checked="" type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07-11-08 Qualifier Peter D.